

Work Order ID 99188***99188***

Page 1

March-28-13 12:55:52 PM

Item ID: D4008-5

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Fuel Filler Splash Guard Hinge Half

Stop

NS2Start Date: 3/27/13 Start Qty: *10x* 5.00***5***

Cust Item ID:

Required Date: 3/27/13 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: *MLS*Date: *13-04-02* Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D4008	C
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100	0.00
-----	------

100	<i>10x</i>
--------------	------------

Small Fab

Memo 0.00

Small Fab

1- Cut MS20257-3 hinge as per dwg D4008, keep 2nd half for D4008-11

2- Drill holes as per dwg

3- Deburr

110

QC5- Inspect part completeness to step on W/O 0.00

110	<i>10</i>
--------------	-----------

QC

Memo 0.00

Quality Control

*QAS
21
98*
134.17


NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS									
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>								
Part No. _____															
NCR No. _____															
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector					
Doc/Data	<input type="checkbox"/>														
Equip/Tooling	<input type="checkbox"/>														
Operator	<input type="checkbox"/>														
Material	<input type="checkbox"/>														
Setup	<input type="checkbox"/>														
Other	<input type="checkbox"/>														
Process	<input type="checkbox"/>														
Supplier	<input type="checkbox"/>														
Training	<input type="checkbox"/>														
Unapproved	<input type="checkbox"/>														
FAULT CATEGORY															
Landing Gear			General												
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions								<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge			<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	
														<input type="checkbox"/> Other	

Picklist Print

March-28-13 12:55:52 PM

Page 1

Work Order ID: 99188 **Start Date:** 3/27/13 **Required Date:** 3/27/13
Parent Item: D4008-5 **Start Qty:** 5.00 **Required Qty:** 5.00
Parent Item Name: Fuel Filler Splash Guard Hinge Half

Comments: IPP rev A 10.02.01 new issue Prelim EC verified by: DD IPP Rev:B 10.05.03 as per ECN10-562 DD verified by:EC IPP REV:C 12.03.07 AS PER DWG REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20257-3-7200 Piano Hinge		Purchased	No			100	f	14.7895	0.377	1.885		3/23/13	/04/13

Location	Loc Qty	Loc Code
ST209a	14.7894732	
123960	14.7894732	

3.77

NCR: Yes / No

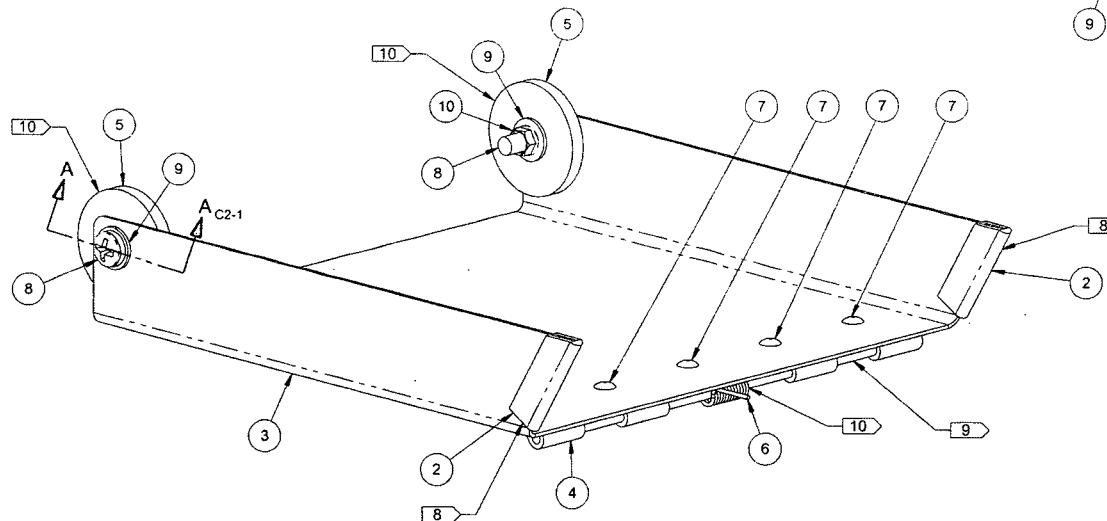
DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS						
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other					
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other												
Process												
Supplier												
Training												
Unapproved												
FAULT CATEGORY												
Landing Gear				General								
Bending		Bend					Ovalized		Pressure/Forced			
Centre Not Concentric to O/S		BOM/Route					Over/Under tolerance		Temperature/Cure			
Cracks		Broken/Damaged					Part Incorrect		Weld			
Crushed/Crimped		Burrs					Part Lost/Missing		Wrong Stock Pulled			
Cuffs		Contamination					Part Moved					
Heat Treat		Countersink					Positioned Wrong					
Inspection Strip in Tube		Cut Too Short					Power Loss/Surge					
Ripples in Bend		Drill Holes					Other					
Torque Waves in Extrusion		Drawing										
Turning Sequence		Finish										
Wave/Twist in Tube		Folio										

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-041	AUX TANK FILLER SPLASH GUARD ASSEMBLY	JCA-M47-2-26
2	2	D3941-1	RUBBER CUSHION	
3	1	D4008-1	FUEL FILLER SPLASH GUARD CHANNEL	
4	1	D4008-5	HINGE HALF	
5	2	D4008-7	WASHER	
6	1	D4008-9	SPRING	
7	5	MS20470AD3-3	RIVET	
8	2	MS35206S245	SCREW	
9	6	NAS1149DN832J	WASHER	
10	2	MS21042L08	NUT	



D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY

NOTES:
 1) MATERIAL: N/A
 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3 

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

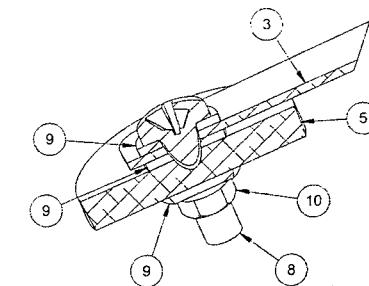
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1

7) WEIGHT: 0.15 lbs

8) ATTACH D3941-1 RUBBER CUSHION USING SILICONE ADHESIVE, TRIM TO FIT, AFTER POWDER COAT

9) MASK HINGE PIN AREA BEFORE POWDER COAT

10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER POWDER COAT



SECTION A-A
SCALE: 2X B6-1
TYP

RELEASED
2012-03-02
MM

REV.	DESCRIPTION	BY	DATE
C	CHANGE POWDER COAT FROM "GREY SANDTEX" TO ANSI 61 GREY. CORRECT MATERIAL ERROR, ZN A7-6. ADD D4597-1 TO D4008-043, ZN C4-2.	DC	12.01.17
B	ADD ALTERNATE RIVETS FOR -043, ZN D7-2	HS	10.11.03
A	NEW ISSUE	HS	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4008	SHEET 1 OF 10
APPROVED		TITLE	SCALE
DE APPR.		SPLASH GUARD	NTS
DATE	12.01.17	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS ISSUED OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

SHOP

FINISH

UNCON

SUBJECT

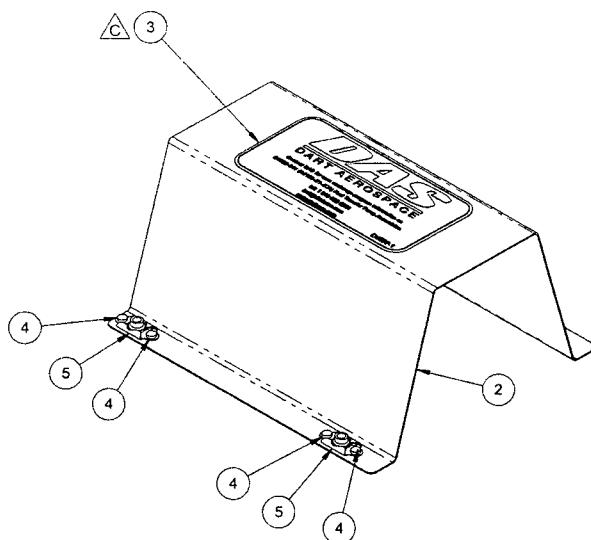
WITH

WORK

NO. 99188 MLJ

13-04-02

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-043	FUEL PUMP SPLASH GUARD ASSEMBLY	JCA-M47-2-29
2	1	D4008-3	FUEL PUMP SPLASH GUARD COVER	
3	1	D4597-1	PLACARD	
4	8	MS20472M3-3	RIVET	
5	4	MS21060L3	ANCHOR NUT	



D4008-043 FUEL PUMP SPLASH GUARD ASSEMBLY

RELEASED
2012-03-02
MK

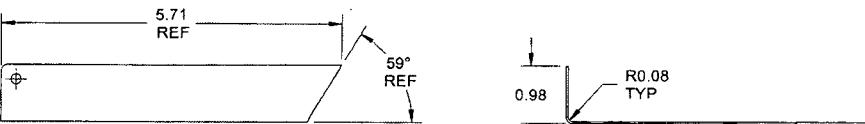
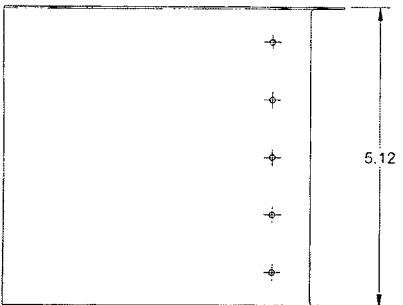
NOTES:

- 1) MATERIAL:
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.46 lbs

DESIGN	<i>AE</i>	DART AEROSPACE LTD
DRAWN	<i>SC</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AE</i>	REV. C
MFG. APPR.	<i>AE</i>	DRAWING NO.
APPROVED	<i>AE</i>	D4008
DE APPR.	<i>AE</i>	SHEET 2 OF 10
DATE	12.01.17	TITLE
		SPLASH GUARD
		SCALE
		NTS

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DART AEROSPACE PART NUMBER D4008-1	JOHN CAMERON AVIATION PART NUMBER REF JCA-M47-2-26
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D4008-1 FUEL FILLER SPLASH GUARD CHANNEL

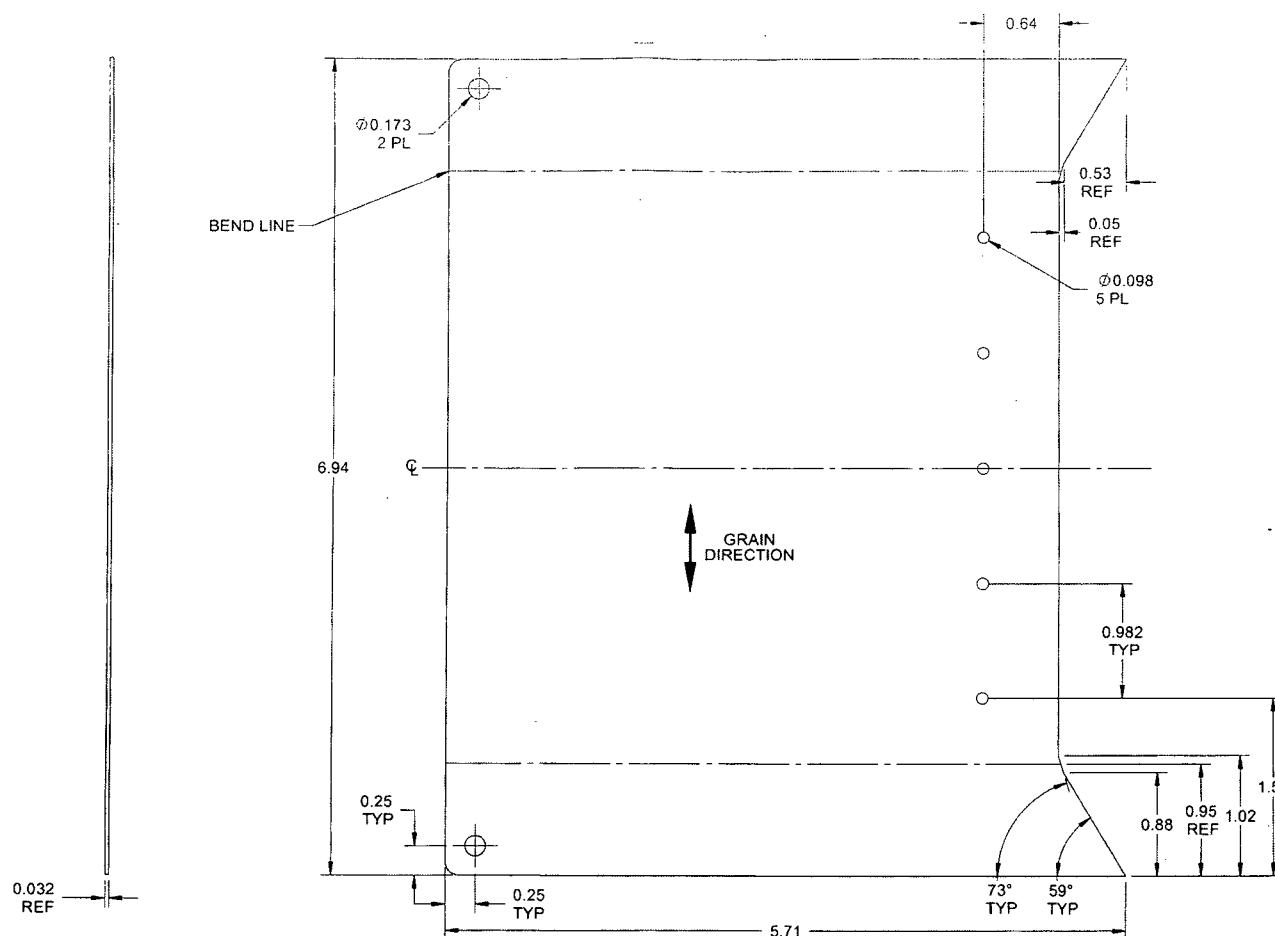
NOTES:

- 1) MATERIAL: MADE FROM D4008-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD
DRAWN	<i>EP</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>EP</i>	REV. C
MFG. APPR.	<i>EP</i>	D4008
APPROVED	<i>EP</i>	SHEET 3 OF 10
DE APPR.	<i>EP</i>	TITLE
DATE	12.01.17	SCALE
		NTS
		SPLASH GUARD

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2012-03-02
JP



NOTES:

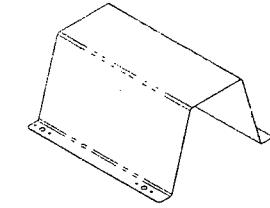
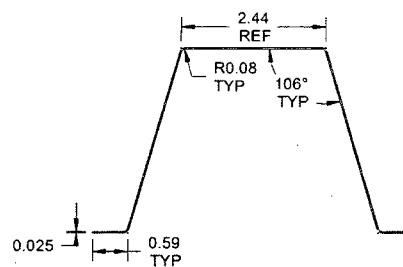
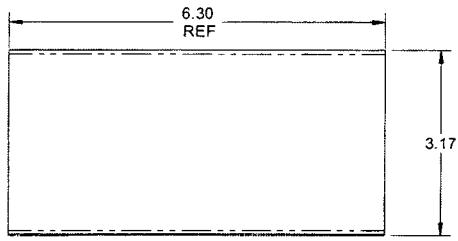
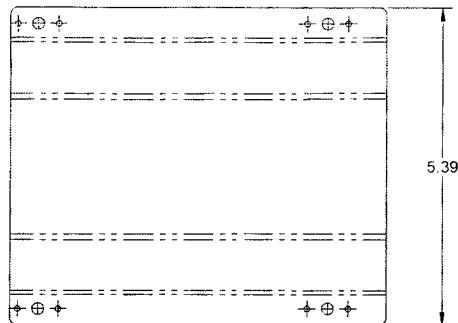
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

RELEASED
2012-03-02
W

DESIGN	<i>AB</i>	DART AEROSPACE LTD
DRAWN	<i>PC</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AB</i>	REV. C
MFG. APPR.	<i>PC</i>	DRAWING NO.
APPROVED	<i>AB</i>	D4008
DE APPR.	<i>AB</i>	SHEET 4 OF 10
DATE	12.01.17	TITLE
		SPLASH GUARD
		SCALE
		NTS
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DART AEROSPACE
PART NUMBER
D4008-3

JOHN CAMERON AVIATION
PART NUMBER
REF JCA-M47-2-29



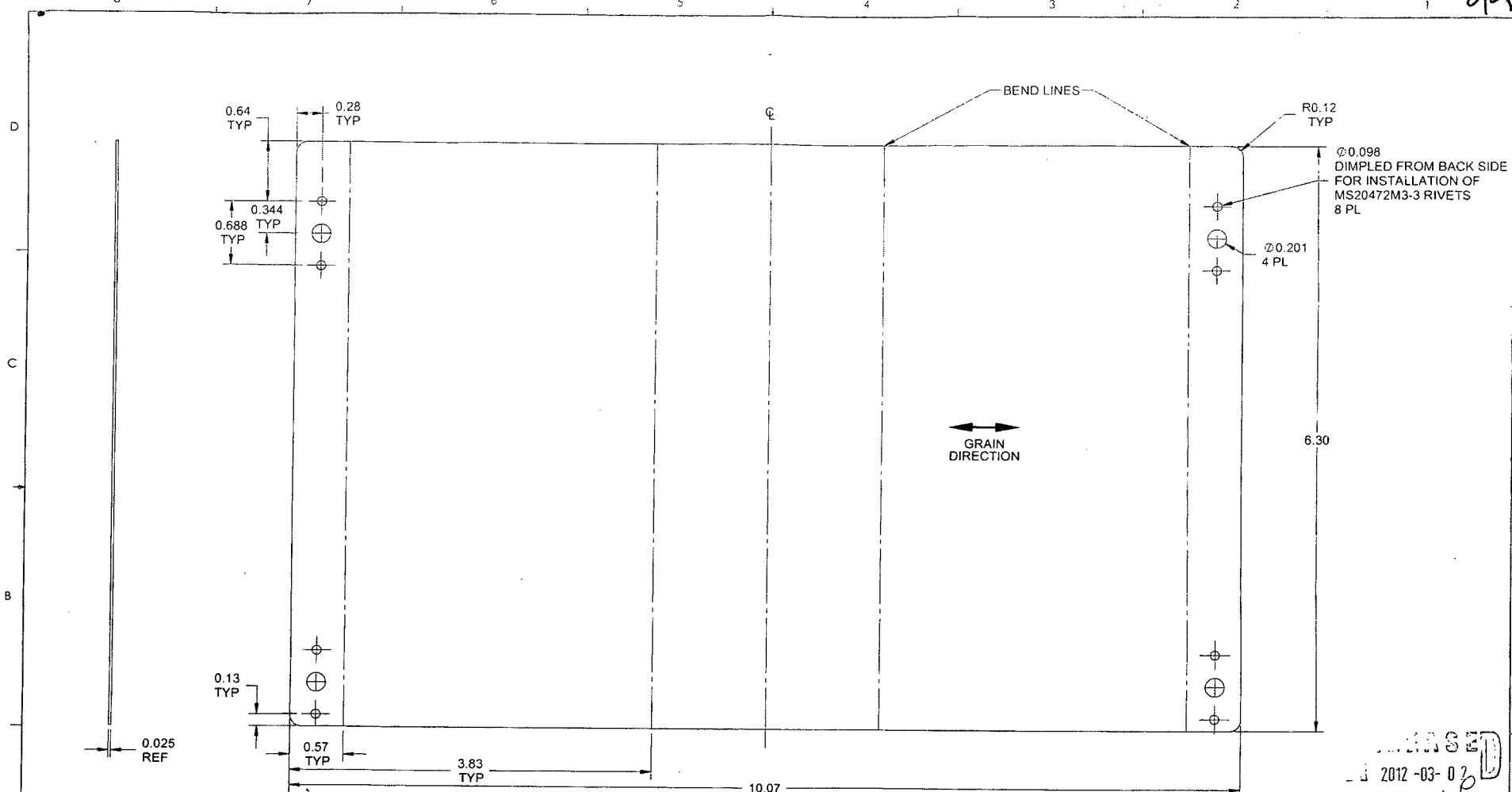
D4008-3 FUEL PUMP SPLASH GUARD COVER

NOTES:

- 1) MATERIAL: MADE FROM D4008-3F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.45 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD
DRAWN	<i>SC</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>SC</i>	REV. C
MFG. APPR.	<i>SC</i>	D4008
APPROVED	<i>SC</i>	SHEET 5 OF 10
DE APPR.	<i>SC</i>	TITLE
DATE	12.01.17	SCALE
		NTS
		SPLASH GUARD
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BASED
7012-03-02
W



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.025 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S24GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.45 lbs

D4008-3F FLAT PATTERN

8 7 6 5 4 3 2 1

DESIGN	AS	DART AEROSPACE LTD
DRAWN	PC	HAWKESBURY, ONTARIO, CANADA
CHECKED	AB	DRAWING NO.
MFG. APPR.	EB	REV. C
APPROVED	MM	D4008
DE APPR.	MM	SCALE
DATE	12.01.17	NTS

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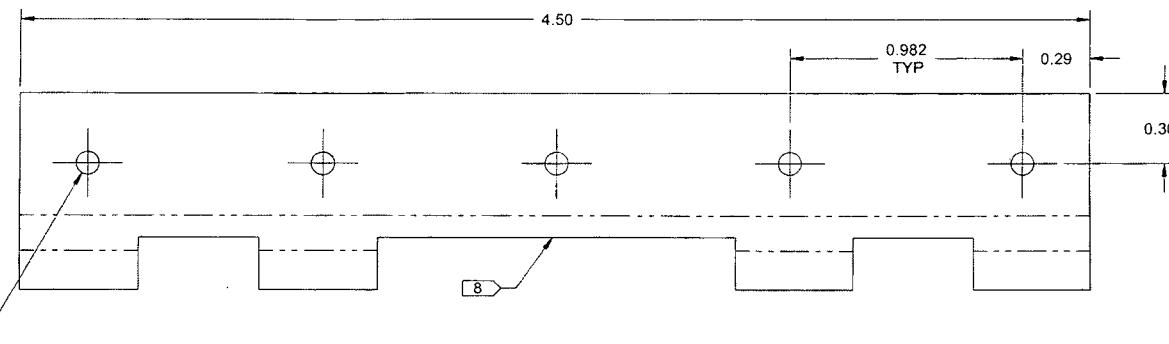
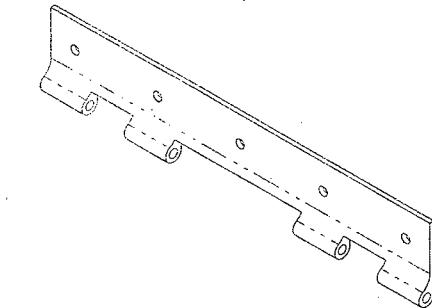
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2

1

99188

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-5	REF JCA-M47-2-26



Ø 0.098
5 PL

D4008-5 HINGE HALF

RELEASED
2012-03-02
NP

NOTES:
 1) MATERIAL: MADE FROM MS20001-4 HINGE OR MS20257-3 HINGE
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.02 lbs
 8) REMOVE CENTER LUG FROM THIS AREA, FLUSH WITH THIS EDGE

DESIGN	<i>AB</i>	DART AEROSPACE LTD
DRAWN	<i>DC</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AB</i>	REV. C
MFG. APPR.	<i>EZ</i>	DRAWING NO. D4008
APPROVED	<i>AB</i>	SHEET 7 OF 10
DE APPR.	<i>AB</i>	TITLE SPLASH GUARD
DATE	12.01.17	SCALE NTS

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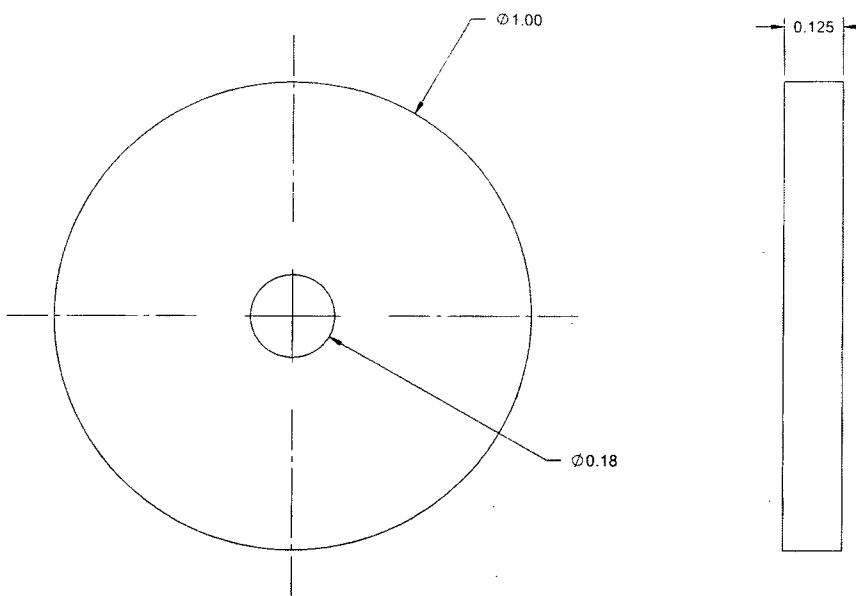
4

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99188

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-7	REF JCA-M47-2-26



D4008-7 WASHER

RELEASER
2012-03-02
MD

A

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, Ø1.00 ROUND BAR, BLACK
REF DART SPEC M-DELRIN-R1.000
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

8

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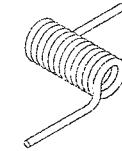
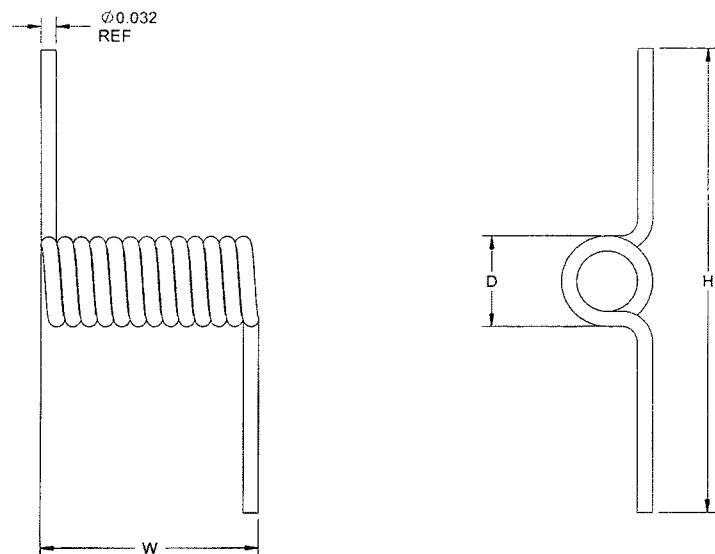
DESIGN	<i>SC</i>	DART AEROSPACE LTD
DRAWN	<i>SC</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>SC</i>	REV. C
MFG. APPR.	<i>SC</i>	DRAWING NO. D4008
APPROVED	<i>SC</i>	SHEET 8 OF 10
DE APPR.	<i>SC</i>	TITLE SPLASH GUARD
DATE	12.01.17	SCALE NTS

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DART AEROSPACE
PART NUMBER
D4008-9

JOHN CAMERON AVIATION
PART NUMBER
REF JCA-M47-2-26

SPECIFICATION CONTROL DRAWING



DART P/N	SUPPLIER	SUPPLIER P/N	WIDTH "W"	HEIGHT "H"	DIAMETER "D"	MATERIAL
D4008-9	VICTORY SPRING	N/A	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE
D4008-9	BELL HELICOPTER	206-031-140-001	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE

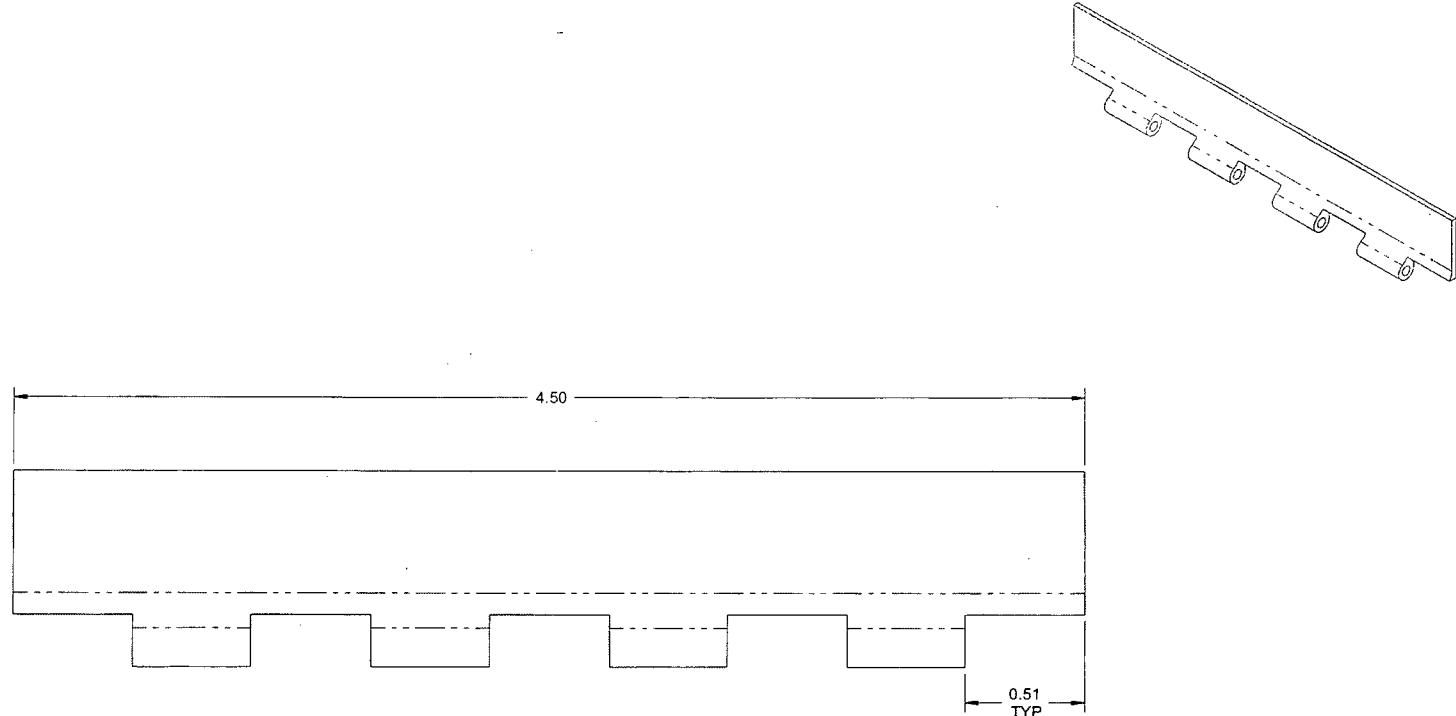
D4008-X SPRING

NOTES:

- 1) MATERIAL: T301 OR 304 STAINLESS STEEL SPRING WIRE Ø0.032 PER ASTM A313
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD
DRAWN	<i>DC</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AS</i>	REV. C
MFG. APPR.	<i>AS</i>	DRAWING NO.
APPROVED	<i>AS</i>	D4008
DE APPR.	<i>AS</i>	SHEET 9 OF 10
DATE	12.01.17	TITLE
		SCALE
		NTS
		SPLASH GUARD
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RELEASED
2012-03-02
MP



D4008-11 TANK HINGE HALF

2012-03-02
MAP

NOTES:

- 1) MATERIAL: MADE FROM MS20001-4 HINGE OR MS20257-3 HINGE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: STOCK AS D4008-11
- 7) WEIGHT: 0.02 lbs

DESIGN	<i>DC</i>	DART AEROSPACE LTD
DRAWN	<i>DC</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>DC</i>	REV. C
MFG. APPR.	<i>DC</i>	DRAWING NO. D4008
APPROVED	<i>DC</i>	SHEET 10 OF 10
DE APPR.	<i>DC</i>	TITLE SPLASH GUARD
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